

Date: Thursday, 12/06/2008 12:44:57 PM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: ARM		
Job Number	39830			Part Number	: D2845		
Estimate Number	11668			Drawing Number	: D2845 REV A		
P.O. Number				Project Number	: N/A		
This Issue	12/06/2008	S.O. No.:		Drawing Revision	: A		
Prsh Rev.	NC			Material	:		
First Issue	/ /	Type	MACHINED PARTS	Due Date	: 19/06/2008 Qty: 10 Um: Each		
Previous Run	37339						
Written By							
Checked & Approved By	<u>L</u>						
Comment	Est: B 00.11.01 Removed P/O for Powder Coat - in house processEC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W035	304 RD Tube .500 x .035W
Comment: Qty.: 1.6109 f(s)/Unit Total : 16.1091 f(s) 304 RD Tube .500 x .035W M304TR0500W035 Punch 304/316 Seamless tubing with 2B finish, 1/2" OD x .035 Wall 17.11" long (Hole ctr. to hole ctr.) using Jig DT 8012 Batch <u>M 108250</u> SR 08/06/12 (10)		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Form per Dwg D2845 using brake andbending Jig DT 8238-C Deburr PT 08-07-14 (10)		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP S 08/07/14 (10)		
4.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3 START TIME: <u>1:00pm</u> OVEN TEMPERATURE: <u>400°F</u> FINISH TIME: <u>1:30pm</u> JL 08-07-14 (10)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(10x)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M.F.

08/07/14

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 205

AS

08/07/15 X10

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/16 JJ

Job Completion



MF 08-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

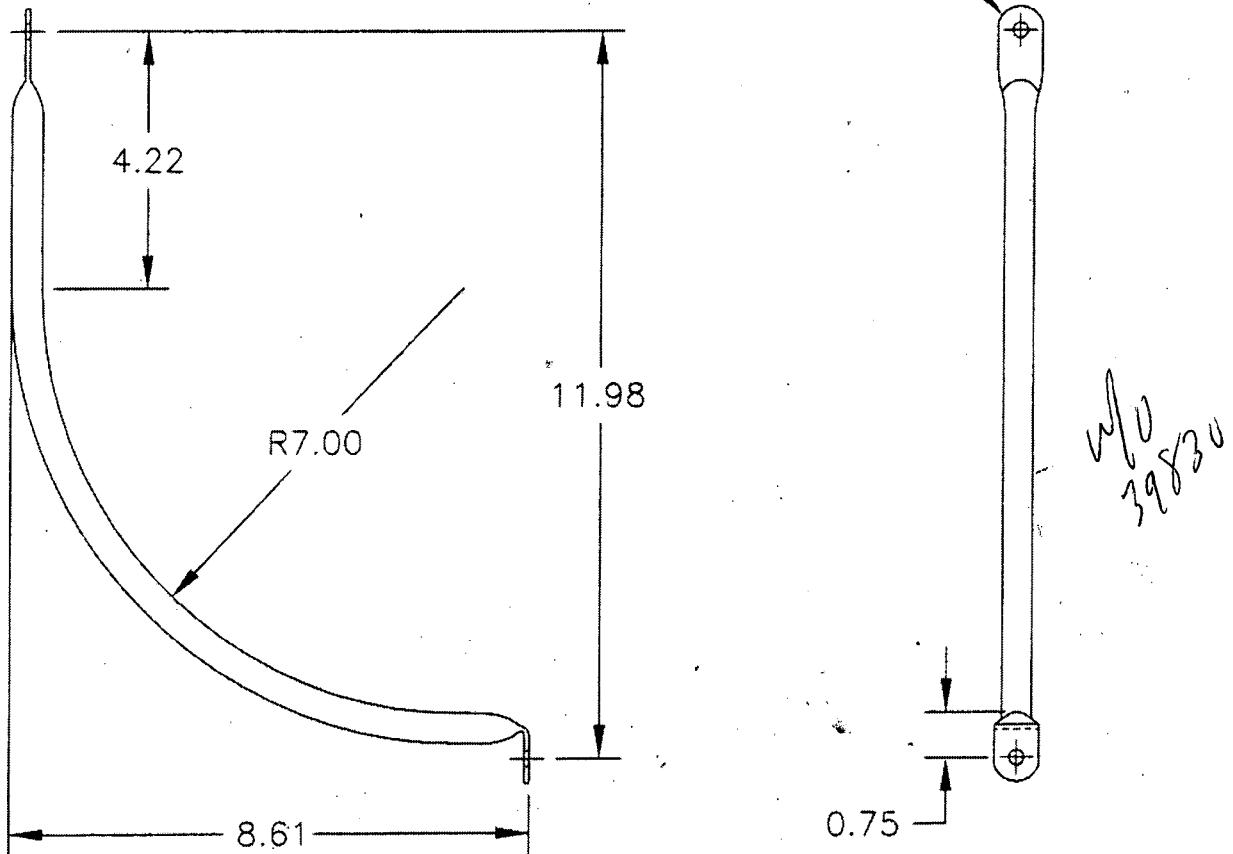
NOTE: Date & initial all entries

DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>PA</i>	APPROVED <i>JS</i>	DRAWING NO. D2845
DATE 98.10.14		TITLE ARM
A	98.10.14	SCALE 1:3 NEW ISSUE

RELEASED
16.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3